

Amendments to the Claims

Please cancel claims 21-43. The pending claims are listed below.

1 Claim 1 (Original): A method for manufacturing a glass or ceramic disk substrate for a rotating
2 disk drive data storage device, comprising the steps of:

3 providing a ceramic or glass disk substrate having a circumferential edge;

4 loading said disk substrate to an edge finishing apparatus; and

5 grinding said circumferential edge of said disk substrate in a ductile grinding regime using
6 said edge finishing apparatus.

1 Claim 2 (Original): The method for manufacturing a glass or ceramic disk substrate of claim 1,
2 wherein said disk drive data storage device is a rotating magnetic disk drive data storage device,
3 said disk substrate being subsequently coated with a magnetic coating after said grinding step.

1 Claim 3 (Original): The method for manufacturing a glass or ceramic disk substrate of claim 1,
2 further comprising the step of coarse grinding said circumferential edge in a non-ductile mode,
3 said step of coarse grinding said circumferential edge in a non-ductile mode being performed
4 before said step of grinding said circumferential edge in a ductile grinding regime.

1 Claim 4 (Original): The method for manufacturing a glass or ceramic disk substrate of claim 1,
2 wherein said disk substrate contains an outer circumferential edge at the periphery thereof and a
3 central aperture defining an inner circumferential edge, and wherein said grinding step is applied
4 to both said outer circumferential edge of said disk substrate and to said inner circumferential
5 edge.

1 Claim 5 (Original): The method for manufacturing a glass or ceramic disk substrate of claim 1,
2 wherein said grinding step comprises grinding said edge with a formed grinding appliance
3 conforming to an edge radius at said circumferential edge.

1 Claim 6 (Original): The method for manufacturing a glass or ceramic disk substrate of claim 1,
2 wherein said grinding step comprises bringing a grinding appliance of said edge finishing
3 apparatus in contact with said circumferential edge and providing relative motion between said
4 grinding appliance and circumferential edge of approximately 30 m/sec or more.

1 Claim 7 (Original): The method for manufacturing a glass or ceramic disk substrate of claim 1,
2 wherein said edge finishing apparatus comprises a grinding appliance having diamond particles of
3 approximately 6 microns or less.

1 Claim 8 (Original): The method for manufacturing a glass or ceramic disk substrate of claim 1,
2 wherein said glass or ceramic disk substrate is finished for installation in a disk drive data storage
3 device without chemical strengthening of said disk substrate.

1 Claim 9 (Original): The method for manufacturing a glass or ceramic disk substrate of claim 8,
2 wherein said glass or ceramic disk substrate is of a material which is not chemically
3 strengthenable.

1 Claim 10 (Original): A method for manufacturing a glass or ceramic disk substrate for a
2 rotating disk drive data storage device, comprising the steps of:
3 providing an ceramic or glass disk substrate having a cut, unfinished circumferential edge,
4 wherein said ceramic or glass disk substrate material is not chemically strengthenable; and
5 finishing said circumferential edge of said disk substrate to a finished state suitable for use
6 in a disk drive data storage apparatus using at least one edge finishing apparatus.

1 Claim 11 (Original): The method for manufacturing a glass or ceramic disk substrate of claim
2 10, wherein said step of finishing said circumferential edge of said disk substrate comprises
3 grinding said edge in a ductile grinding regime.

1 Claim 12 (Original): The method for manufacturing a glass or ceramic disk substrate of claim
2 10, wherein said disk drive data storage device is a rotating magnetic disk drive data storage
3 device, said method further comprising the step of coating at least one flat surface of said disk
4 substrate with a magnetic coating, said coating step being performed after said grinding step.

1 Claim 13 (Original): The method for manufacturing a glass or ceramic disk substrate of claim
2 10, wherein said disk substrate contains an outer circumferential edge at the periphery thereof and
3 a central aperture defining an inner circumferential edge, and wherein said finishing step
4 comprises finishing both said outer circumferential edge of said disk substrate and said inner
5 circumferential edge.

1 Claim 14 (Original): The method for manufacturing a glass or ceramic disk substrate of claim
2 10, wherein said step of finishing said circumferential edge grinding step comprises forming an
3 edge radius at said circumferential edge.

1 Claim 15 (Original): A method for manufacturing a glass or ceramic disk substrate for a rotating
2 disk drive data storage device, comprising the steps of:

3 providing a ceramic or glass disk substrate having a cut, unfinished circumferential edge;
4 finishing said circumferential edge of said disk substrate to a finished state suitable for use
5 in a disk drive data storage apparatus by application of mechanical forces using at least one edge
6 finishing apparatus, said finishing step being accomplished without chemical strengthening of
7 said glass disk substrate.

1 Claim 16 (Original): The method for manufacturing a glass or ceramic disk substrate of claim
2 15, wherein said disk substrate is of a material which is not chemically strengthenable.

1 Claim 17 (Original): The method for manufacturing a glass or ceramic disk substrate of claim
2 15, wherein said step of finishing said circumferential edge of said disk substrate comprises
3 grinding said edge in a ductile grinding regime.

1 Claim 18 (Original): The method for manufacturing a glass or ceramic disk substrate of claim
2 15, wherein said disk drive data storage device is a rotating magnetic disk drive data storage
3 device, said method further comprising the step of coating at least one flat surface of said disk
4 substrate with a magnetic coating, said coating step being performed after said grinding step.

1 Claim 19 (Original): The method for manufacturing a glass or ceramic disk substrate of claim
2 15, wherein said disk substrate contains an outer circumferential edge at the periphery thereof and
3 a central aperture defining an inner circumferential edge, and wherein said finishing step
4 comprises finishing both said outer circumferential edge of said disk substrate and said inner
5 circumferential edge.

- 1 Claim 20 (Original): The method for manufacturing a glass or ceramic disk substrate of claim
2 15, wherein said step of finishing said circumferential edge grinding step comprises forming an
3 edge radius at said circumferential edge.

Claims 21-43 (Cancelled)